

Shg today to Eng 6

Work Order ID 64481



Page 1

December 6, 2010 2:36:32 PM

Item ID: D4274-3

Revision ID:

Item Name: Plate, Aft Support

Start Date: 12/06/10 Start Qty: 2.00

Required Date: 12/06/10 Req'd Qty: 2.00

Reference:

PRELIMINARY ISSUE

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: u

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4274	PBT C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

B10-126

(2)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



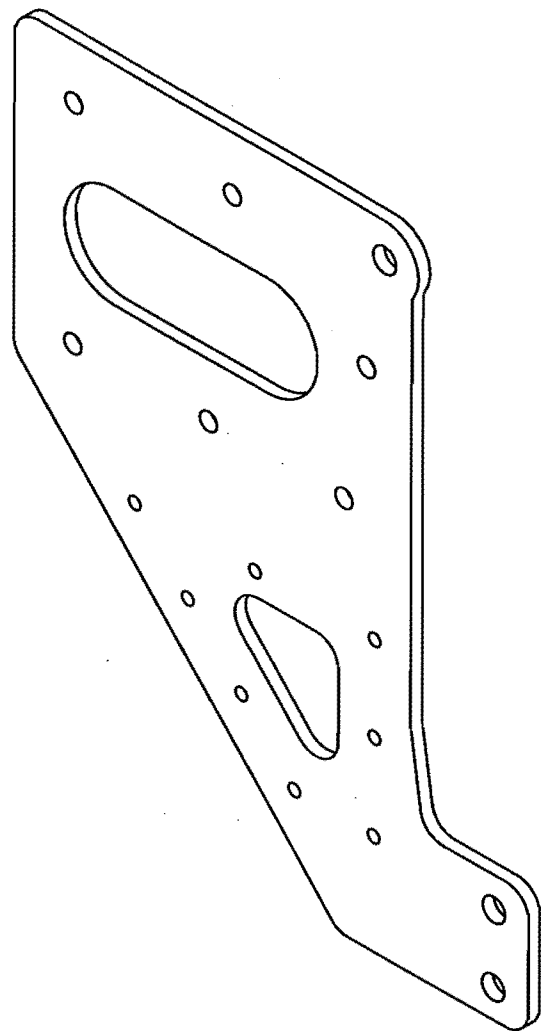
QC

Memo

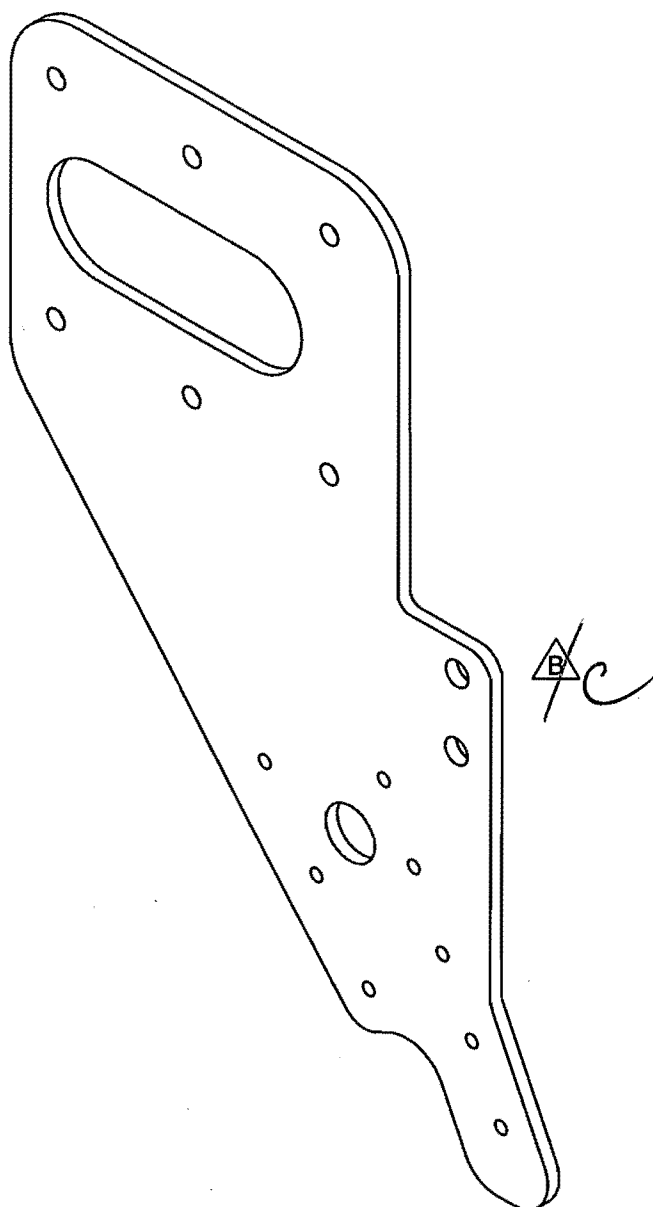
0.00

Quality Control

B10-126



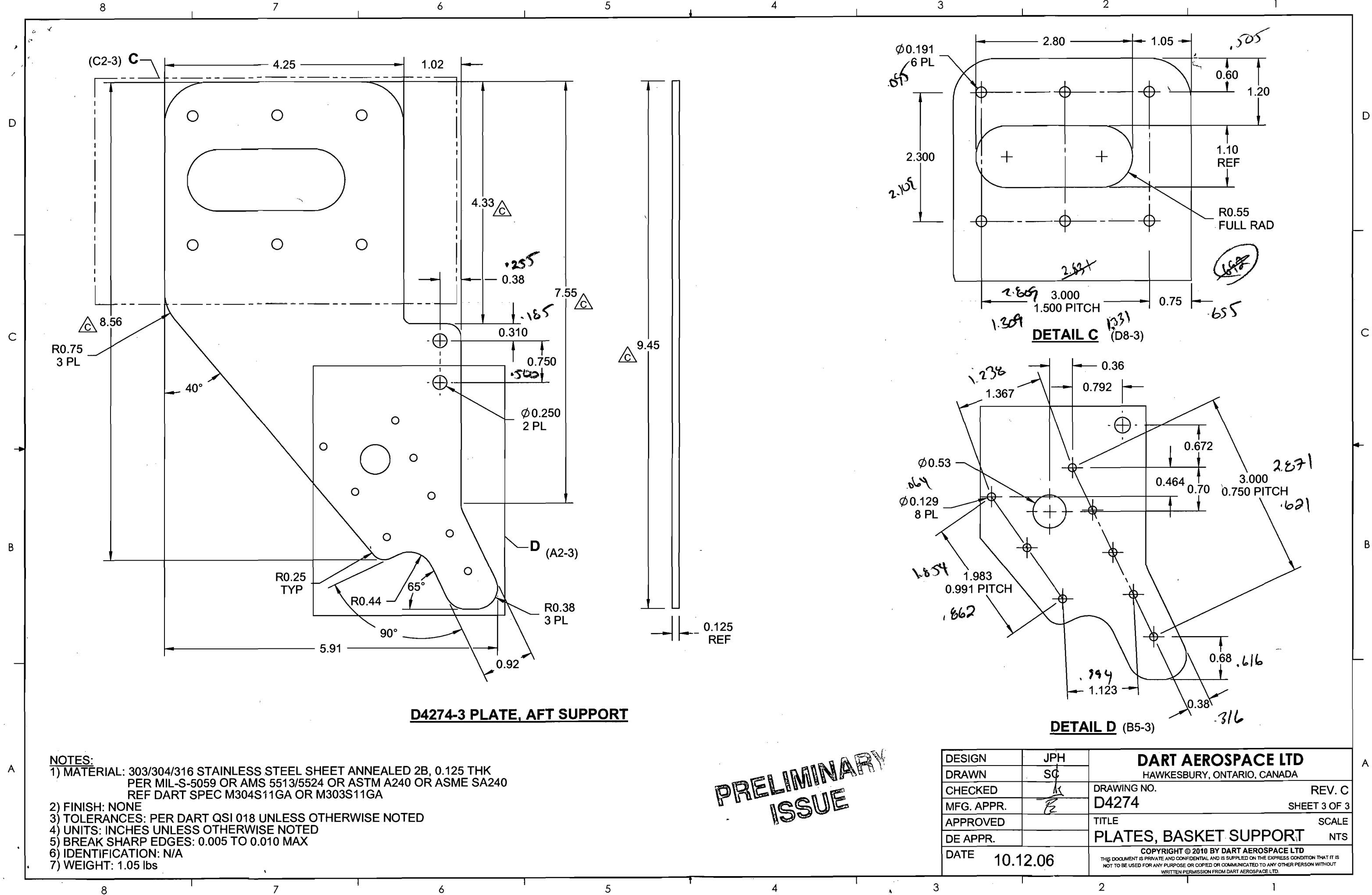
**D4274-1 PLATE, FWD SUPPORT**



**D4274-3 PLATE, AFT SUPPORT**

**PRELIMINARY  
ISSUE**

0.5"			
B	D4274-1, D4274-3 PLATES LENGTH INCREASED BY 0.25"; HOLES OPENED TO 0.25" FOR AN4 BOLTS	SC	10.12.02
A	NEW ISSUE	SC	10.11.30
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4274	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		PLATES, BASKET SUPPORT	NTS
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**NOTES:**  
1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA OR M303S11GA  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 1.05 lbs

**PRELIMINARY  
ISSUE**

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D4274</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>PLATES, BASKET SUPPORT</b>	NTS
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 64481
<b>Description:</b> PLATE, AFT Support		<b>Part Number:</b> D4274-3
<b>Inspection Dwg:</b> D4274-3, Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.131	✗		✓ HB02	
Ø .191	+ .005 - .001	.193	✗		✓	
Ø .250	+ .005 - .001	.251	✗		✓	
Ø .53	+ .012 - .001	.530	✗		✓	
4.25	± .030	4.259	✗		✓	
1.02	± .030	1.018	✗		✓	
4.33	± .030	4.328	✗		✓	
.38	± .030	.378	✗		✓	
.310	± .010	.312	✗		✓	
.750	± .010	.750	✗		✓	
7.55	± .030	7.586	✗		✓	
.92	± .030	.923	✗		✓	
5.91	± .030	5.917	✗		✓	
8.56	± .030	8.551	✗		✓ PRO B02	
2.80	± .030	2.80	✗		✓	
1.05	± .030	1.055	✗		✓	
.60	± .030	.597	✗		✓	
1.20	± .030	1.210	✗		✓	
1.10	± .030	1.095	✗		✓	
.75	± .030	.755	✗		✓	
3.000	± .010	2.998	✗		✓	
1.500	± .010	1.499	✗		✓	
2.300	± .010	2.301	✗		✓	

<b>Measured by:</b> HB	<b>Audited by:</b> S	<b>Prototype Approval:</b>
<b>Date:</b> 10-12-16	<b>Date:</b> 10/12/16	<b>Date:</b>

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 64481
<b>Description:</b> PLATE, Aft Support		<b>Part Number:</b> D4274-3
<b>Inspection Dwg:</b> D4274-3, Rev: C		Page 1 of 1

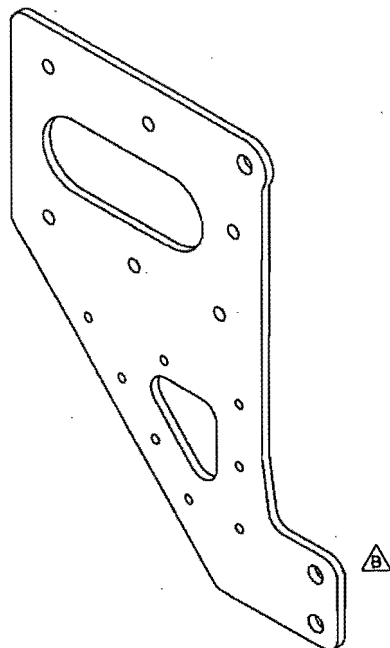
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

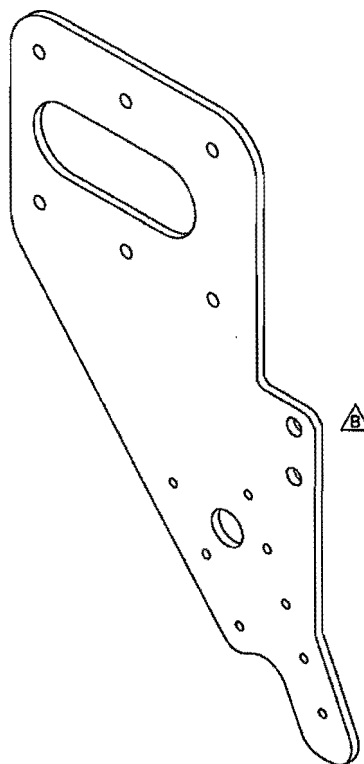
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.367	±.010	1.366	x		V <sup>11</sup> B07	
.36	±.030	.372	x		V	
.792	±.010	.794	x		V	
.672	±.010	.673	x		V	
.464	±.010	.464	x		V	
.70	±.030	.70	x		V	
3.000	±.010	3.004	x		V	
.750	±.010	.752	x		V	
.68	±.030	.681	x		V	
.38	±.030	.382	x		V	
1.123	±.010	1.123	x		V	
1.983	±.010	1.982	x		V	
.991	±.010	.992	x		V	
9.45	±.030	9.451	x		V	
.125	±.010	.117	x		V	

<b>Measured by:</b> IB	<b>Audited by:</b> S	<b>Prototype Approval:</b>
<b>Date:</b> 10-12-6	<b>Date:</b> 10/12/06	<b>Date:</b>

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	



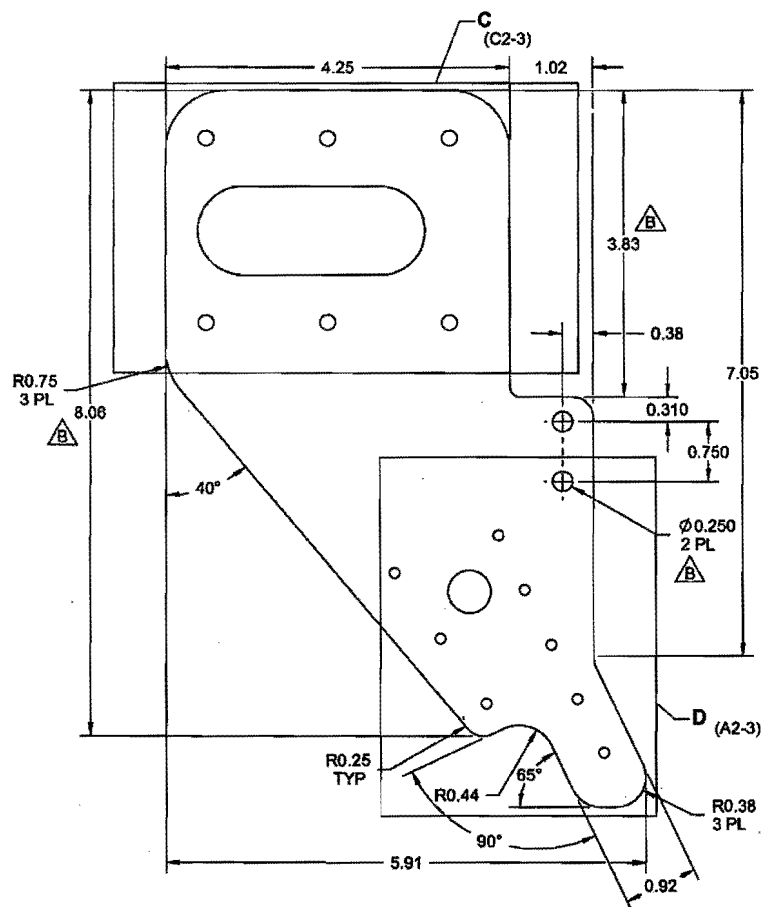
**D4274-1 PLATE, FWD SUPPORT**



**D4274-3 PLATE, AFT SUPPORT**

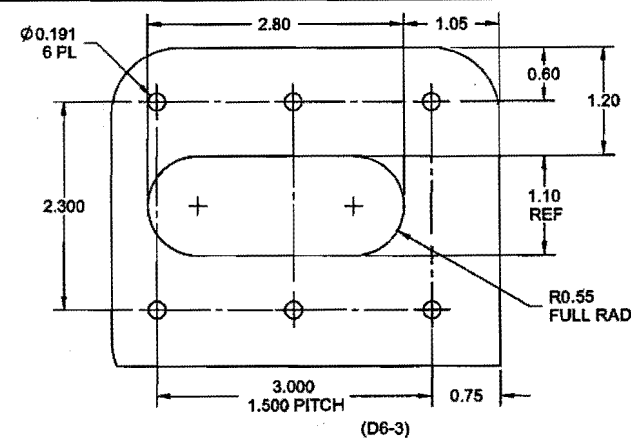
**REFERENCE ONLY**

B	D4274-1, D4274-3 PLATES LENGTH INCREASED BY 0.25"; HOLES OPENED TO 0.25" FOR AN4 BOLTS	SC	10.12.02
A	NEW ISSUE	SC	10.11.30
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4274	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		PLATES, BASKET SUPPORT	NTS
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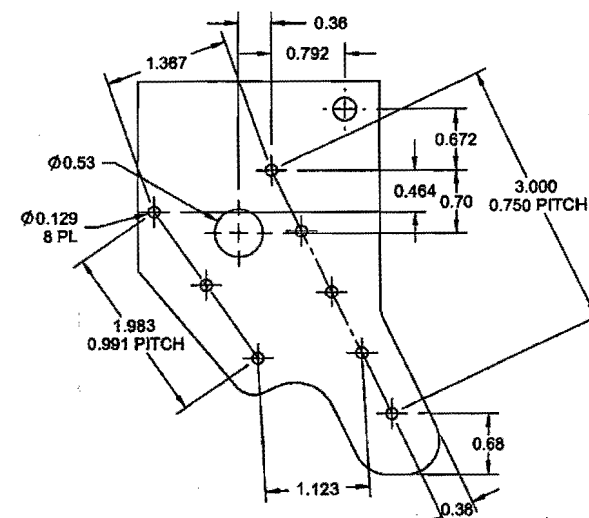


**D4274-3 PLATE, AFT SUPPORT**

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA OR M303S11GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.97 lbs



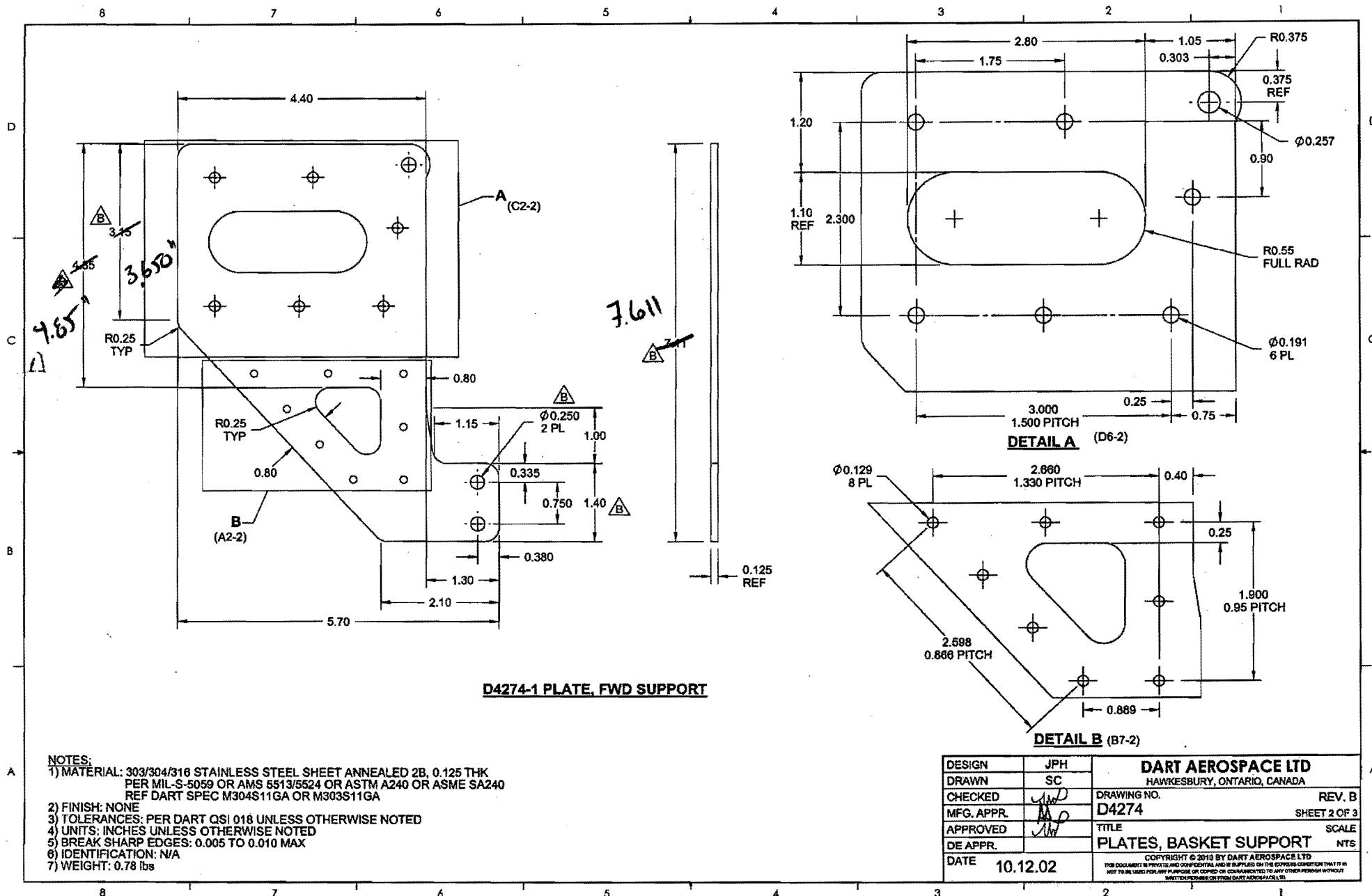
**DETAIL C**



**DETAIL D (B5-3)**

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	WJP	DRAWING NO.	REV. B
MFG. APPR.	WJP	<b>D4274</b>	SHEET 3 OF 3
APPROVED	WJP	TITLE	SCALE
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REFERENCE ONLY





**L Lacelle**

---

**From:** Mike Petsche [mpetsche@dartaero.com]  
**Sent:** December 6, 2010 1:56 PM  
**To:** Sridhar Chintapalli; 'Chris Provencal'; 'L Lacelle'; 'Eric Charbonneau'; 'David Duval'  
**Cc:** 'David Shepherd'  
**Subject:** RE: NEW PARTS PLEASE!!!!

Oh.....and they need t be fedex'ed to us today!

Thanks

XOXOXOXOX

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**From:** Mike Petsche [mailto:mpetsche@dartaero.com]  
**Sent:** December 6, 2010 1:55 PM  
**To:** Sridhar Chintapalli; 'Chris Provencal'; 'L Lacelle'; 'Eric Charbonneau'; 'David Duval'  
**Cc:** 'David Shepherd'  
**Subject:** NEW PARTS PLEASE!!!!  
**Importance:** High

42  
D4274-1 and D4274-3

I know it's a little late in the game.... But Sri, as I mentioned in my email this weekend, The pasket is still a little too high for the 407

Could you drop everything right away and modify the D4274-1 and D4274-3 plates to make them an additional ½" taller than they are. Basically do exactly what you did before. But we need an additional ½"

**Mike Petsche**

DART Aerospace  
Design Manager

613-632-5200  
514-833-1657

12/06/10